

Date: Saturday, 11/19/2005 10:32:40 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOAT SKIDTUBE ASSEMBLY
Job Number : 24798A	
Estimate Number : 10309	
P.O. Number : <i>N/A</i>	Part Number : D206642541
This Issue : 11/19/2005 S.O. No. : <i>N/A</i>	Drawing Number : D3274 REV C
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : C
Previous Run : 24797A	Material : <i>N/A</i>
Written By : _____	Due Date : 12/20/2005 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D26001240	Extrusion Round 3" 206
-----	-----------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1, D2600-1-240 3" OD Tube

B10422 DP05-11-23

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------

**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

DP05-11-23

2-Drill #40 Aft cap pilot hole using DT8025

DP 05-11-23

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

DP05-11-23

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

DP05-11-23

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

DP 05-11-23

6-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274

DP 05-11-28

7-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274

DP05-11-28

8-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

DP05-11-28

Date: Saturday, 11/19/2005 10:32:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24798A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

3.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

A.M 05-11-24

4.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-01-23

5.0

D3282041

I-Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

B21862

Pm' 06-01-24 ①

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

m19795

Sikaflex expire date:

06-06-20

Start: 7:15

Time: 7:15

Finish: 06-01-25

Time: 7:00

a.m 06-01-25 ①

(Adhere for 12 hours)

Pm' 06-01-24 ①

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 06-1-30 ①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

2-Cut Fwd end of tube to length as per Dwg D3274

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

DP 06-1-30 ①

BE 06-01-30 ①

PRO
Last
page



Date: Saturday, 11/19/2005 10:32:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24798A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill pilot holes for wearplates using D3274-1T2, then open to ~~0.257"~~ 0.257" (without cutting fluid) *BE 06-01-30 ①*

5-Deburr *BE 06-01-30 ①*

6-C'sink cross bolt holes as per Dwg D3274 *BE 06-01-30*

9.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3285-1

Fwd Cap

B 21744

BE 06-02-02 ①

10.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D2649

Crossbolt spacer

B 24200

BE 06-02-02 ①

11.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1

Crossbolt spacer

B 24861

BE 06-02-02 ①

12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod

M15855/m19100

BE 06-02-02 ①

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

M15855

BE 06-02-02 ①

3-Grind welds flush to Fwd cap on top surface only.

BE 06-02-02 ①

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube

BE 06-02-02 ①

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

BE 06-02-02 ①

Date: Saturday, 11/19/2005 10:32:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24798A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore. Inspect for foreign objects as per QSI 024

06-02-07
PD 06-02-07

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M102391

06/12/07

yl 06/11/07 X X

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 12 07 ①

16.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3415-041	Nut Plate	2524574

17.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CCR264SS3-3	Rivet	101938

18.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CR3212-4-03	Rivet	159841

yl 06/12/07

Date: Saturday, 11/19/2005 10:32:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24798A

Part Number: D206642541

Job Number:



Seq. #: Machine Or Operation: Description :

19.0 D26483 Wearpad



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 D2648-3 Wearpad 28123

20.0 D265615 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-15 Wearshoe 29845

21.0 D265623 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-23 Wearshoe 29846

22.0 D265635 Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2656-35 Wearshoe 26206

23.0 D32871 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3287-1 Wearshoe 20889

24.0 D34291 WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3429-1 Wearpad 29201

FC/YL
06/12/07

Date: Saturday, 11/19/2005 10:32:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24798A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

25.0	AN960C10L	Inventory
------	-----------	-----------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	AN960C10L	Washer	10340

26.0	MS27039C108	SCREW
------	-------------	-------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	MS27039C1-08Screw		19185

27.0	NAS1330C3KB116	Insert
------	----------------	--------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	NAS1330C3KB116 Inserts		19349

28.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
78	NAS1515H3L Washer		02404

29.0	D34131	RING
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3413-1	Ring	24869

30.0	AN4C5A	BOLT
------	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C5A	Bolt	M18918

FC/yl D6/12/07

Date: Saturday, 11/19/2005 10:32:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24798A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

31.0	AN960C416L	Inventory
------	------------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN960C416L	Washer	16651

32.0	NAS1515H4L	Inventory
------	------------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	NAS1515H4L	Washer	1015412

33.0	D2646	Aft Cap
------	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2646	Aft Cap	28041

34.0	AN960C10L	Inventory
------	-----------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	101340

35.0	MS27039C108	SCREW
------	-------------	-------



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
12	MS27039C1-08Screw		19185

36.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	102404

FC/yl

06/12/07

Date: Saturday, 11/19/2005 10:32:41 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 24798A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/LPS-3 101915

2-Install inserts & wearpads as per Dwg D3274. Use a drop of Sikaflex inside insert holes and a layer of sikaflex between wearplates and skidtube.

A/R Sikaflex-291 102672

Sikaflex expire date: 02/07

3-Install ring as per Dwg D3274

A/R Sikaflex-291 102672

Sikaflex expire date: 02/07

4-Inspect for foreign objects as per QSI 024

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 102672

Sikaflex expire date: 02/07

FC/YL
06/12/08

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J 07-01-09 (1)

39.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07-01-12 (1)

Job Completion



U 07-01-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-11-23	4	QL 3/5. perm change <i>[Signature]</i>				<i>[Signature]</i> 05-10-23	<i>[Signature]</i> 06-11-23

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 07/01/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

